

A B S T R A C T

FORGE WELDING OF HEAVY DUTY TUBULARS

A method of joining heavy duty oilfield, well, or other tubulars includes the step of joining the tubulars by forge welding and flushing a reducing flushing gas around the heated tubular ends during at least part of the forge welding operation such that oxides are removed from the forge welded tubular ends and the amount of oxide inclusions and irregularities between the forge welded tubular ends is limited. The tubular ends may have a teathed sinusoidal or other non-planar shape to inhibit any abrupt variations of the wall strength in the welding area and/or to reduce shear forces to the forge weld when the tubulars are twisted and/or radially expanded.